



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D350-748-143TRN
Job Sheet 173667



Part No: D350-748-143TRN

Job Qty: 1 ea

Part Name: Ss Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A NEW ISSUE - PRELIM - LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		M.D. [Signature]
100	Mori Seiki	1 pcs		4/17/18	7.06	2.81	Mori Seiki TL-40		M.D. [Signature]
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. [Signature]
120	Mori Seiki	1 pcs		4/17/18	0.00	2.81	Mori Seiki TL-40		M.D. [Signature]
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. [Signature]
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		GP 18-06-20
150	Crosstubes	1 pcs		4/18/18	0.00	0.97	Crosstubes-2		DPZ 18-06-27
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		DPZ 18-06-27
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		21 JUN 27 2018

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-141 on both ends. 2-Face both sides of Descriptions: tube. 3- Turn program 02000 section on both side as per folio FB467. 4- Turn program 03000 section on both side as per folio FB467. 5- Blend transsition lines only with belt sander 60 grit Dwg rev: A
120 - 1- Turn program 04000 section on both side as per folio FB467. 2- Blend transsition lines only with belt sander 60 grit 3- Scribe part # as per Dwg D350-748-143
130 - PERFORME ULTRASONIC MEASURMENT
150 - 1-Grind machining marks
190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

3127272

Part Specifications

Specifications could not be found.

Plex 3/6/18 12:16 PM Dart.Gagnon.Michelle



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Container No: S081384



Part: D350-748-143TRN

Job No: 173667

Serial No/Batch: S081384

Revision:

Inspector:

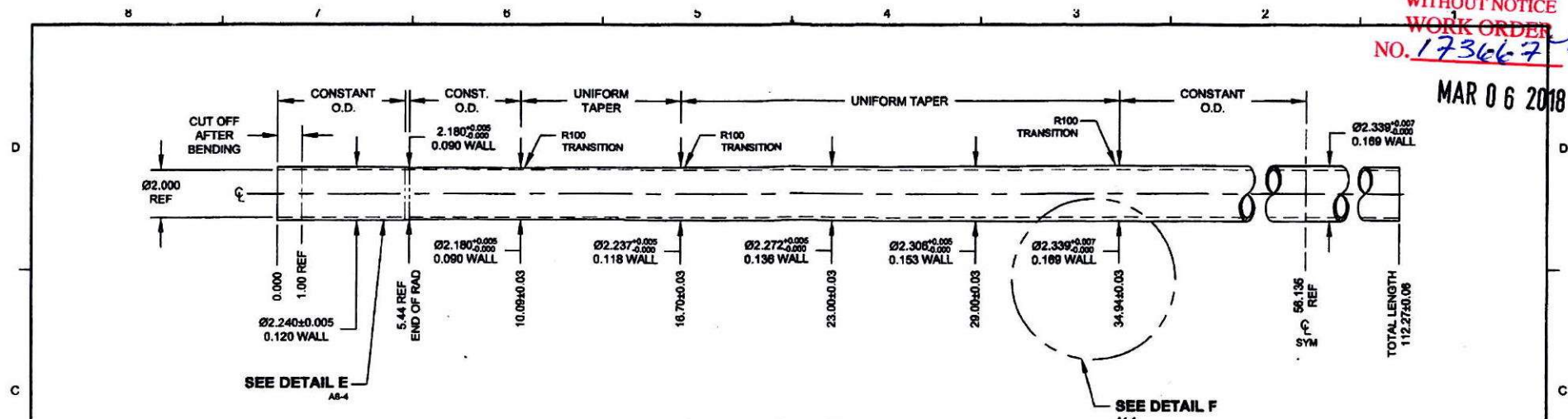
Exp Date:

Instructions:

Date: 08/15/18

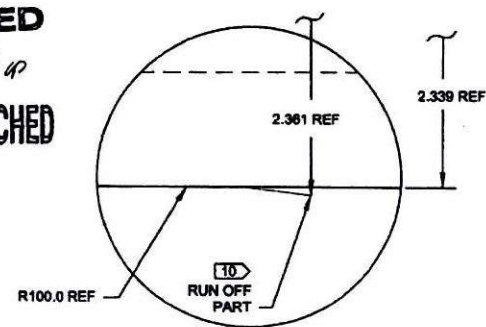
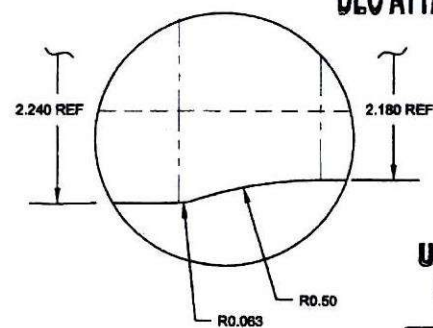
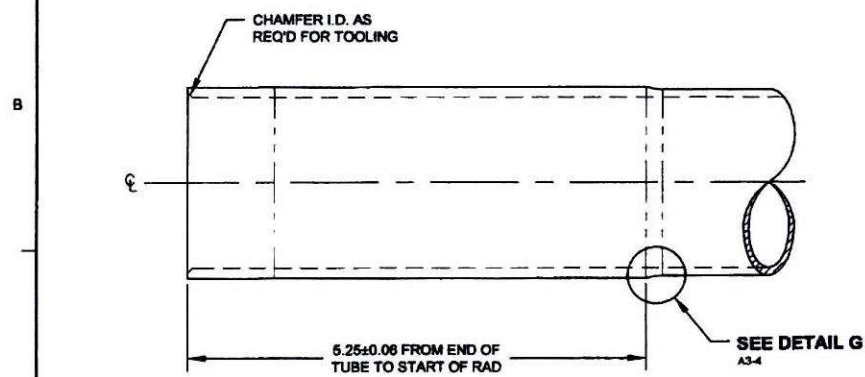
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173667 *msl*

MAR 06 2018



**D350-748-143TRN
TURNING DETAIL**

RELEASED
2015 MAR 18 *ap*
DEO ATTACHED



UNDER REVIEW
15/01/28

DESIGN	<i>ap</i>	DART AEROSPACE LTD	
DRAWN	<i>ap</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ap</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ap</i>	D350-748-143	SHEET 4 OF 4
APPROVED	<i>ap</i>	TITLE	SCALE
DE APPR.	<i>ap</i>	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	15.01.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD	

⑦

DART AEROSPACE LTD	Work Order:	<i>173667</i>
Description: Crosstube Assembly (AS350/355 High Fwd SS)	Part Number:	D350-748-143
Inspection Dwg: D350-748-143 Rev: A		Page 1 of 2

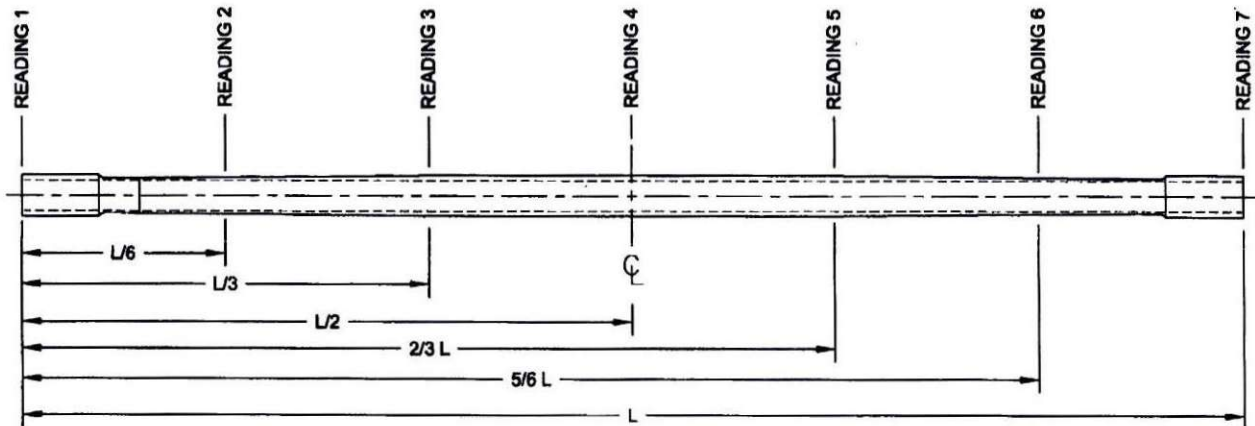
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	<i>2.245</i>	✓		<i>BLM 3" 04</i>	
	2.180	+0.005/-0.000	<i>2.185</i>	✓			
	2.180	+0.005/-0.000	<i>2.185</i>	✓			
	2.237	+0.005/-0.000	<i>2.241</i>	✓			
	2.272	+0.005/-0.000	<i>2.276</i>	✓			
	2.306	+0.005/-0.000	<i>2.310</i>	✓			
	2.339	+0.007/-0.000	<i>2.346</i>	✓		<i>Vern 08</i>	
	2.339	+0.007/-0.000	<i>2.345</i>	✓		<i>Vern 08</i>	
	0.062	+/-0.010	<i>.062</i>	✓		<i>RG</i>	
	5.25	+/-0.060	<i>5.249</i>	✓		<i>Vern 08</i>	
	R0.063	+/-0.010	<i>.063</i>	✓		<i>RG</i>	
	R0.50	+/-0.030	<i>.500</i>	✓		<i>RG</i>	
SIDE B	2.240	+/-0.005	<i>2.245</i>	✓		<i>BLM 3" 04</i>	
	2.180	+0.005/-0.000	<i>2.185</i>	✓			
	2.180	+0.005/-0.000	<i>2.185</i>	✓			
	2.237	+0.005/-0.000	<i>2.242</i>	✓			
	2.272	+0.005/-0.000	<i>2.277</i>	✓			
	2.306	+0.005/-0.000	<i>2.311</i>	✓			
	2.339	+0.007/-0.000	<i>2.3455</i>	✓		<i>Vern 08</i>	
	2.339	+0.007/-0.000	<i>2.346</i>	✓		<i>Vern 08</i>	
	0.062	+/-0.010	<i>.062</i>	✓		<i>RG</i>	
	5.25	+/-0.060	<i>5.249</i>	✓		<i>Vern 08</i>	
	R0.063	+/-0.010	<i>.063</i>	✓		<i>RG</i>	
	R0.50	+/-0.030	<i>.500</i>	✓		<i>RG</i>	
	112.27	+/-0.060	<i>112.27</i>	✓		<i>Tape</i>	

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Description: Crosstube Assembly (AS350/355 High Fwd SS)	Part Number: D350-748-143
Inspection Dwg: D350-748-143 Rev: A	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.143	.136	.134	.140	.009	0.030"
READING 2 L= 18.71	.141	.140	.136	.145	.009	
READING 3 L= 37.42	.193	.195	.187	.186	.009	
READING 4 L= 56.14	.189	.189	.189	.189	0	
READING 5 L= 74.85	.183	.192	.198	.189	.015	
READING 6 L= 93.56	.140	.141	.139	.139	.002	
READING 7 L= 112.27	.137	.136	.133	.140	.007	

Calibration Result

Actual Block Thickness: 100-200

Sitescan 250 Measured Thickness: 100-200

Measured by: M.D. [Signature]
Date: 2018-06-14

Audited by: SP
Date:

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue (P/O D350-748-103)	KJ [Signature]	JA [Signature]